

Work Order ID 77437-2

77437

Page 1

December-07-11 7:45:11 AM

Item ID: D4095-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 07/12/2011 Start Qty: 6.00

Required Date: 21/12/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: M.L.S.

Date: 11/12/07 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	B								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4095-3)								
304, 063	Dwg Rev: <u>1B</u>								
	Prog Rev: <u>1B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B11-12-8

(8)

B11-12-8

(78)

Swirlog

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77437

77437

December-07-11 7:45:11 AM

Item ID: D4095-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 07/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

1- bend section C-C first
 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155
 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

0.00

0.00

SB 11/12/13

(8)

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

Ensure joggle as per dwg D4095

S-11/12/13

(X8)

150

150

Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: 11/20/15 0.00
 Large Fab

Memo

0.00

X2 JBL 12-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77437

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December-07-11 7:45:11 AM

Item ID: D4095-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 07/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Run

Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QS1004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

S12/01/17

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

S12/01/17

(x2)

180

0.00

180

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH: 119947

/A 12-01-17

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77437

77437

December-07-11 7:45:11 AM

Item ID: D4095-043

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 07/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

8/12/17

+2

200

Identify as per dwg & Stock Location: FP-1

0.00

200

Packaging

Memo

0.00

Packaging

2x f 12/10/17
counted & measured

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/1/18
12-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-07-11 7:45:17 AM

Page 1

Work Order ID: 77437

77437

Parent Item: D4095-043

D4095-043

Parent Item Name: Wearplate Assembly

Start Date: 07/12/2011

Required Date: 21/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	237.6000	2.275	14.36842	18		

M304S16GA

304/316 Sheet .063

**

1811-12-8

Location

Loc Qty

Loc Code

MAT020

237.6

119653

237.6

119653

8

DART AEROSPACE LTD		Work Order:	77437
Description: Wearplate		Part Number:	D4095-3
Inspection Dwg: D4095	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.191	✓		V B57	
0.300	+/-0.010	0.301	✓		V	
0.300	+/-0.010	0.303	✓		V	
2.432	+/-0.010	2.434	✓		V	
3.227	+/-0.010	3.227	✓		V	
4.06	+/-0.030	4.053	✓		V	
2.50	+/-0.030	2.500	✓		V	
4.98	+/-0.030	4.984	✓		V	
8.43	+/-0.030	8.430	✓		T B51	
11.50	+/-0.030	11.50	✓		T	
21.750	+/-0.010	21.750	✓		T	
3.500	+/-0.010	3.500	✓		V	
12.22	+/-0.030	12.22	✓		T	
6.000	+/-0.010	6.000	✓		T	
12.100	+/-0.010	12.100	✓		K	
21.00	+/-0.030	21.00	✓		T	
30.000	+/-0.010	30.000	✓		T	
36.000	+/-0.010	36.000	✓		T	
38.88	+/-0.030	38.88	✓		T	
0.063	+/-0.010	0.059	✓		V	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 11-12-8	Date: 11/12/09	Date:

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)

77437 M.C.J
11/12/07

D4095-1
WEARPLATE

D4095-041 WEARPLATE ASSEMBLY

PLUS ONE
ROCKGUARD

D4095-3
WEARPLATE

D4095-043 WEARPLATE ASSEMBLY

D4095-5
WEARPLATE

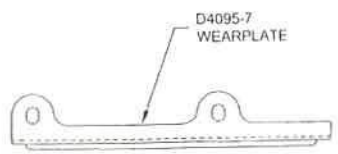
D4095-045 WEARPLATE ASSEMBLY

D4095-041/-043/-045/-047/-049/-051 NOTES:

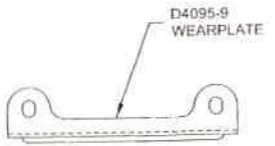
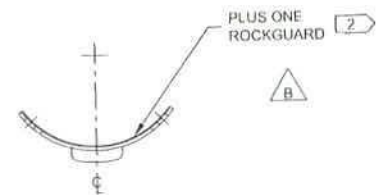
- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4095-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED	MP		
MFG. APPR.	MP		
APPROVED	MP		
DE APPR.	MP		
DATE	11.10.18		
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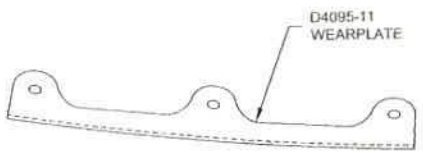
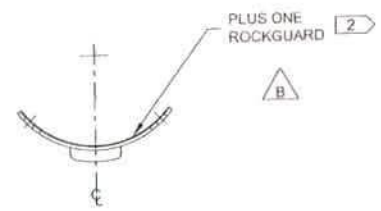
77437



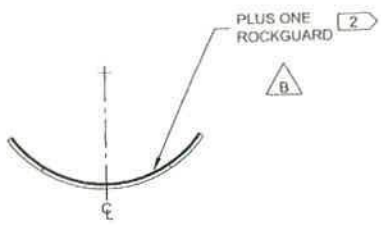
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY



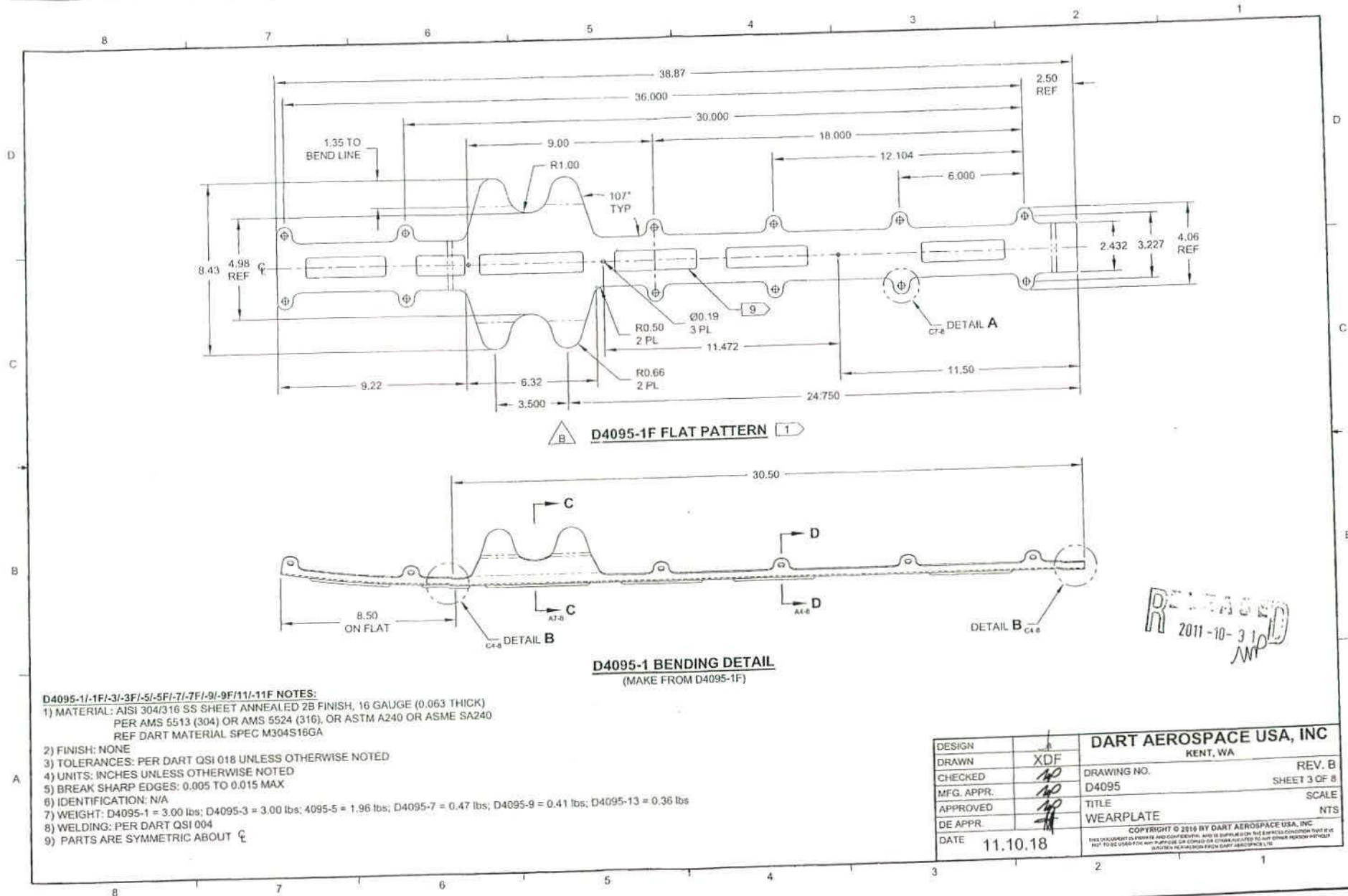
D4095-051 WEARPAD ASSEMBLY



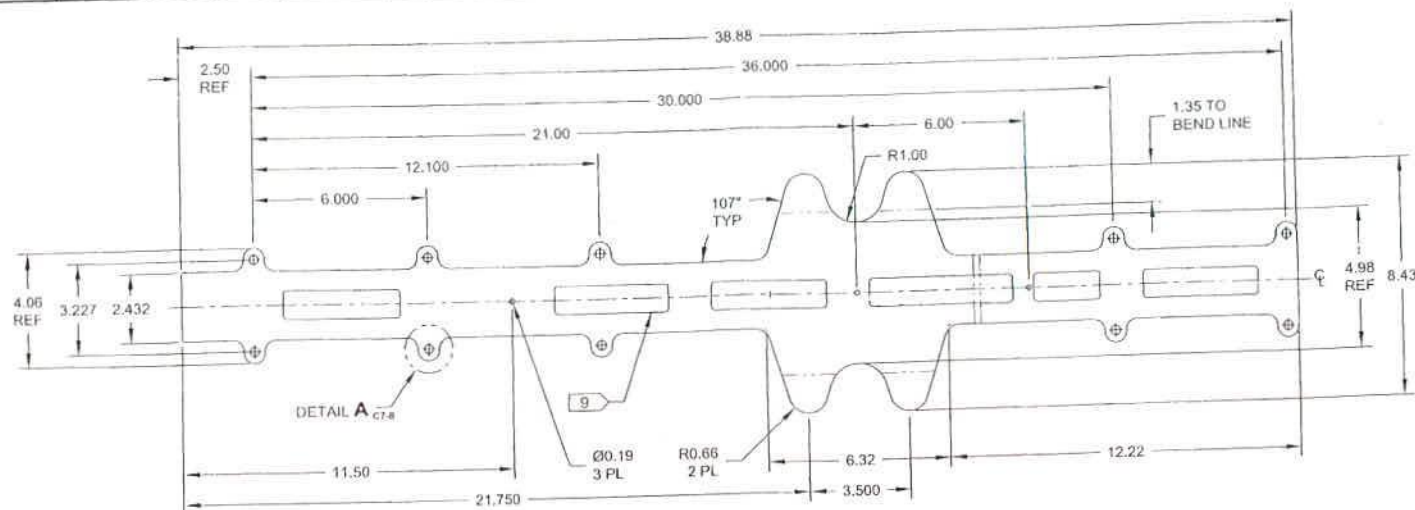
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MFG. APPR.	<i>140</i>	D4095	SHEET 2 OF 8
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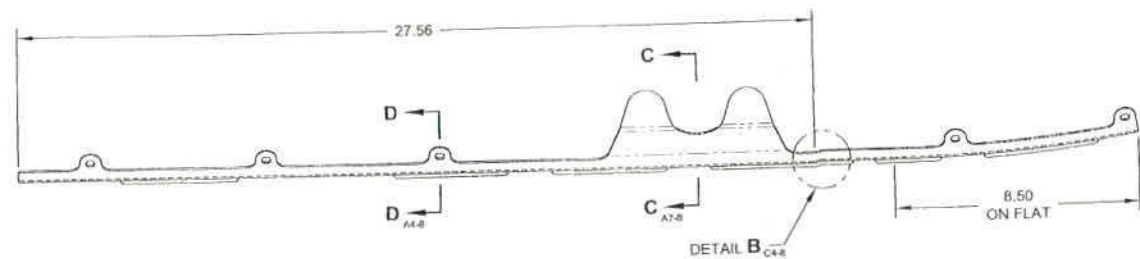
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D4095-3F FLAT PATTERN 1

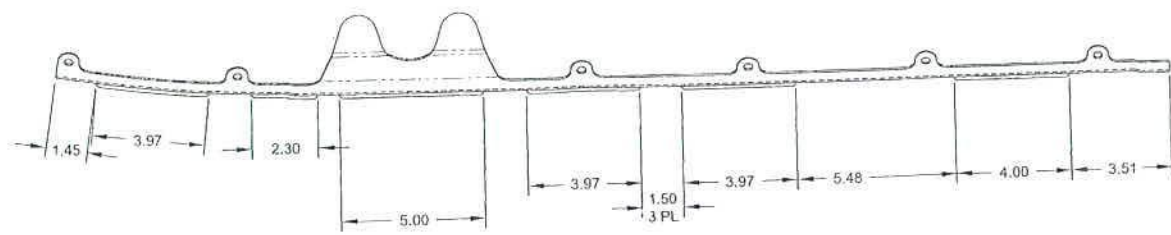



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

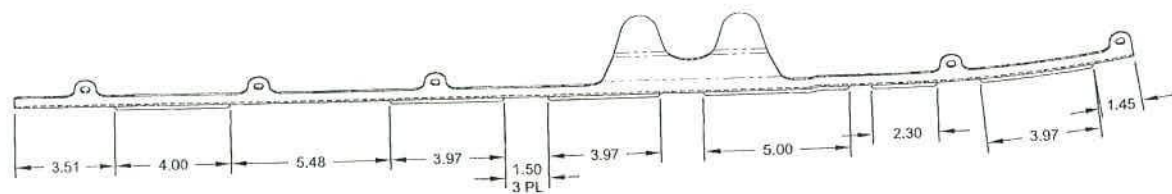
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D4095-1 WELDING DETAIL 



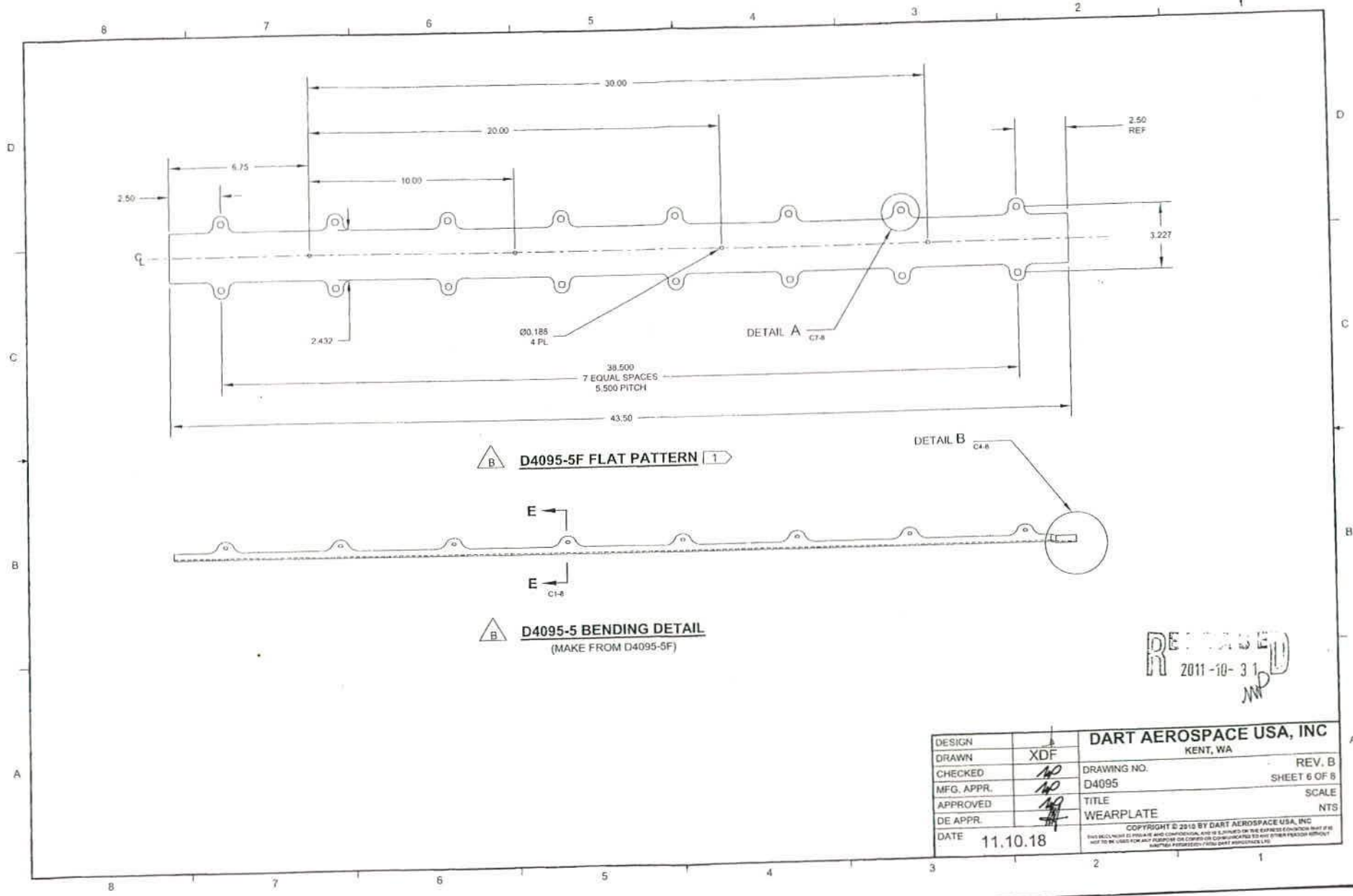
D4095-3 WELDING DETAIL 

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2011-10-31
MR

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KENT, WA		
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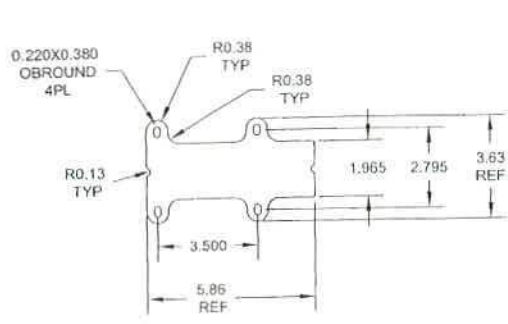


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2011-10-31
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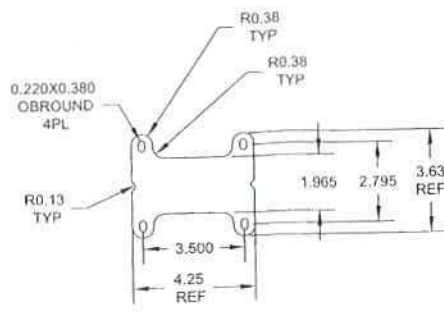
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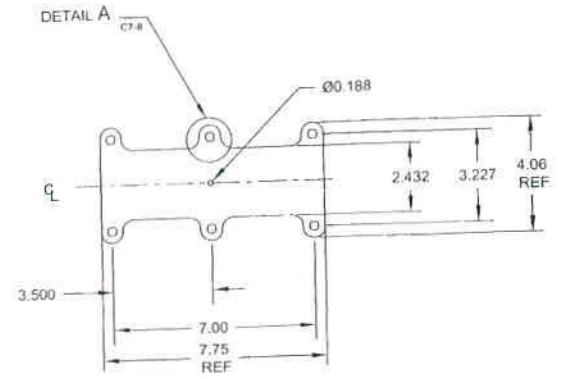
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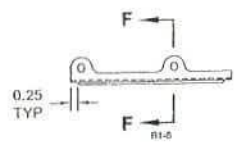
D4095-7F FLAT PATTERN 1



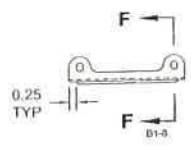
D4095-9F FLAT PATTERN 1



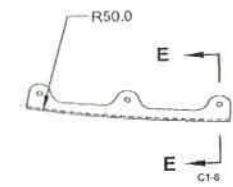
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)

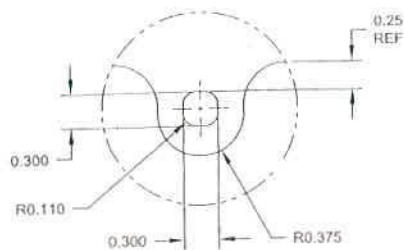


D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

2011-10-31

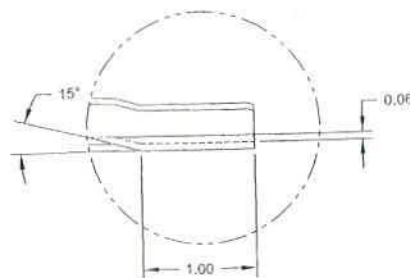
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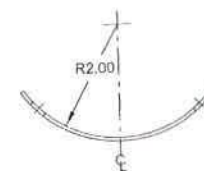
DETAIL A: TAB DETAIL

SCALE 4X
C3-3
C5-4
Q3-6
Q2-7

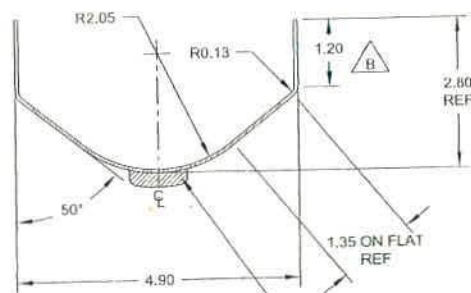


DETAIL B: JOGGLE DETAIL

SCALE 4X
B2-3
B6-3
B3-4
B2-6

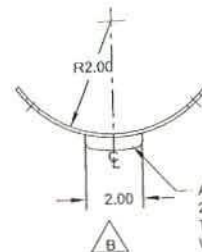


SECTION E-E
SCALE 2X
B5-6
B2-7



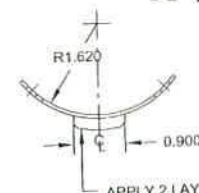
SECTION C-C
SCALE 2X
B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION D-D
SCALE 2X
B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F
SCALE 2X
B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-31
MP

DART AEROSPACE USA, INC			
DESIGN		KENT, WA	
DRAWN	XDF	DRAWING NO.	REV. B
CHECKED	10	D4095	SHEET 8 OF 8
MFG. APPR.	10	TITLE	SCALE
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